

Date: Thursday, 2/8/2007 12:42:57 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET	
Job Number : 30718		
Estimate Number : 10347		
P.O. Number : N/A	Part Number : D28572	
This Issue : 2/8/2007 S.O. No. : N/A	Drawing Number : D2857 REV A/B	
Prsht Rev. : NC	Project Number : N/A	
First Issue : N/A	Drawing Revision : A/B	
Previous Run : 29022	Material : N/A	
Written By : _____	Due Date : 3/20/2007	Qty: 24 Um: Each
Checked & Approved By : _____		
Comment : Est C 00.06.22 Removed P/O for powder coat EC		
Est D 06.03.30 Added level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
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Comment: Qty.: 0.4594 f(s)/Unit Total: 11.0250 f(s)
 Material: 2.00" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B200001250)
 Batch M14890 X 6
 M16615 X 4
 M100451 X 15

SD 07.02.12

(25)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 5.2"

SD 07.02.12

(25)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2857-2

M/J.F.

07/02/13

(24)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M/J.F.

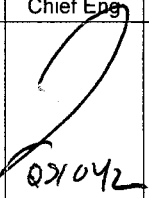

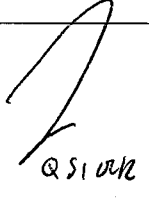

07/02/13

(24)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/13	3	My Z origine was off, causing the end mill to go too deep into the part.	 02/04/2	Scrap and replace Destroy	J.F. 07/02/13	 07/02/16	 05/02/16	 07/02/16

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 30718

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SN 07.02.16

(24)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

J.F. 07/02/16

(24)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

SL/14

07-02-19

(24)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-02-19

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

MR/a.n

07/02/19

(24x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/2/20 (24)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5

PC 7/2/20

24

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/20

Job Completion



07.02.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857 Rev: A B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

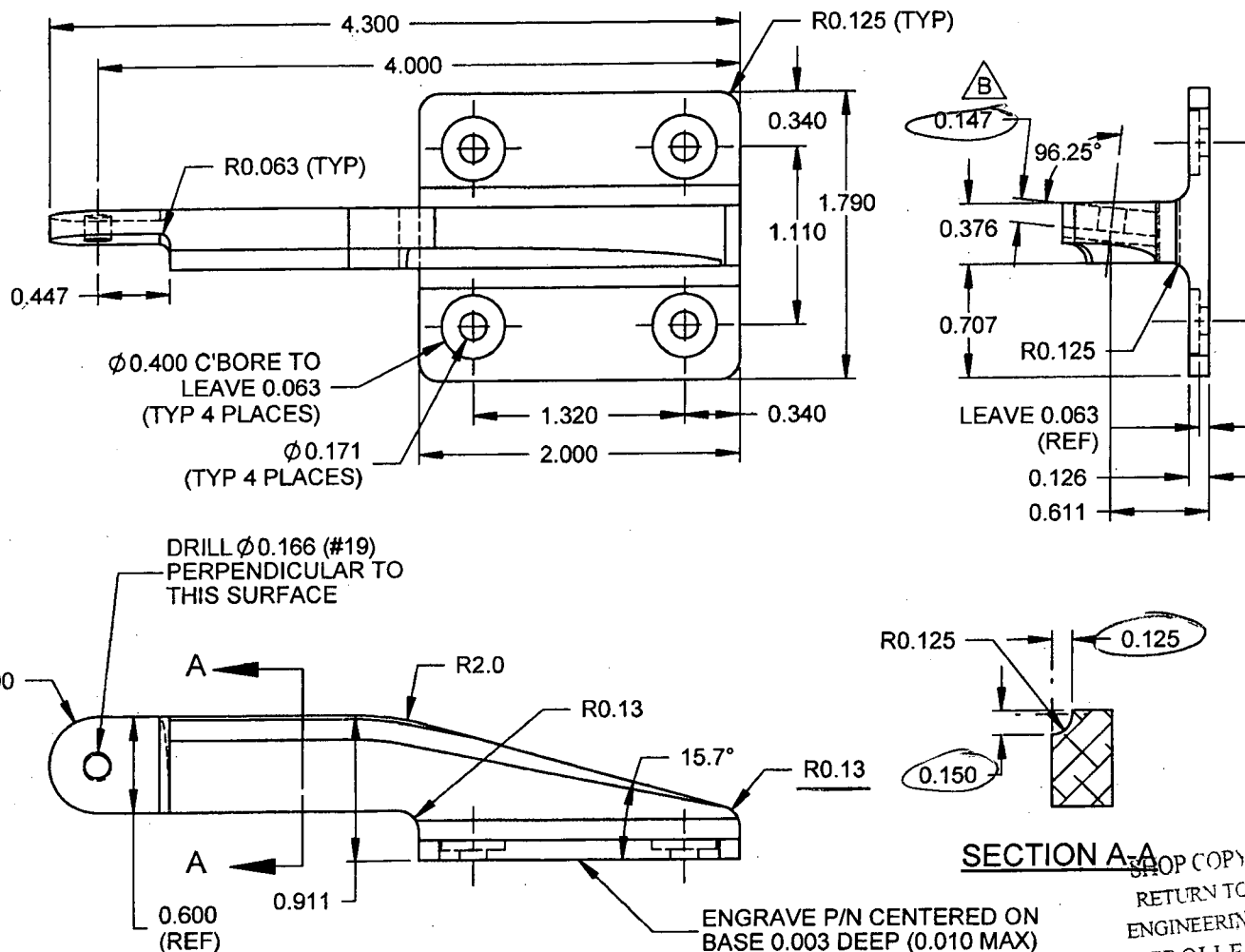
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.310"	✓			
0.340	+/-0.010	.339"	✓			
1.110	+/-0.005	1.113"	✓			
1.790	+/-0.010	1.791"	✓			
1.320	+/-0.005	1.323"	✓			
2.000	+/-0.010	1.995"	✓			
Ø0.171	+0.005/-0.000	.173"	✓			
0.147	+/-0.010	.150"	✓			
0.376	+/-0.010	.378"	✓			
0.126	+/-0.010	.121"	✓			
0.611	+/-0.010	.605"	✓			
0.063	+/-0.010	.058"	✓			
Ø0.166	+0.005/-0.000	Ø.167"	✓			
0.911	+/-0.010	0.914"	✓			
0.600	+/-0.010	.605"	✓			
0.125	+/-0.010	.128"	✓			
0.150	+/-0.010	.150"	✓			

Measured by: J.F.	Audited by: J.F.	Prototype Approval:	N/A
Date: 07/02/13	Date: 07/02/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS. REDRAW W/ SOLIDWORKS	

RELEASED
06-10-13

D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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WORK ORDER
NO. 30718